

Monday, 07/07/2008 8:36:28 AM

User:

Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BACK LEG
Job Number :	40317		
Estimate Number :	13378		
P.O. Number :		Part Number :	D37721
This Issue :	07/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3772 REVA
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JUD 08.7.07	Due Date :	30/07/2008
Comment :	Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC		

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR1250W125

304 RD Tube 1.250 x .125w



Comment: Qty.: 2.3100 f(s)/Unit Total: 9.2400 f(s)

304 RD Tube 1.250 x .125w

BATCH: M 108432

FF 08-07-08 (4)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3772

2-drill holes thru on both ends of tube as per dwg D3772

3- deburr

4-bend tube as per dwg D3772

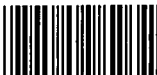
FF 08-07-08 (4)

FF 08-07-10 (4)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/10 (4)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST266

SS 08/07/10 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: N/A Fault Category: Part has ~~AS~~ mod & small NCR: (Yes) No DQA: D Date: 08/07/15
D412-769 QA: N/C Closed: D Date: 08/07/15

NCR: <u>40317</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/9	# 20	After Drilling Part employee realized that he had that driven the far end into wrong	<u>PH</u> <u>01.08.09</u> <u>QSE</u> <u>042</u>	Scrap and Destroy and replace B2 <u>100432</u> <u>Q10</u> PART IS STRUCTURAL	<u>08/07/09</u> <u>FF</u>	<u>S</u> <u>08/07/10</u>	<u>M</u> <u>01.07.09</u> <u>QSE</u> <u>042</u>	<u>C</u> <u>08/07/09</u>
		R.C. Rampage in shop is high and lack of attention.						

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 8:36:28 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK LEG

Job Number: 40317

Part Number: D37721

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

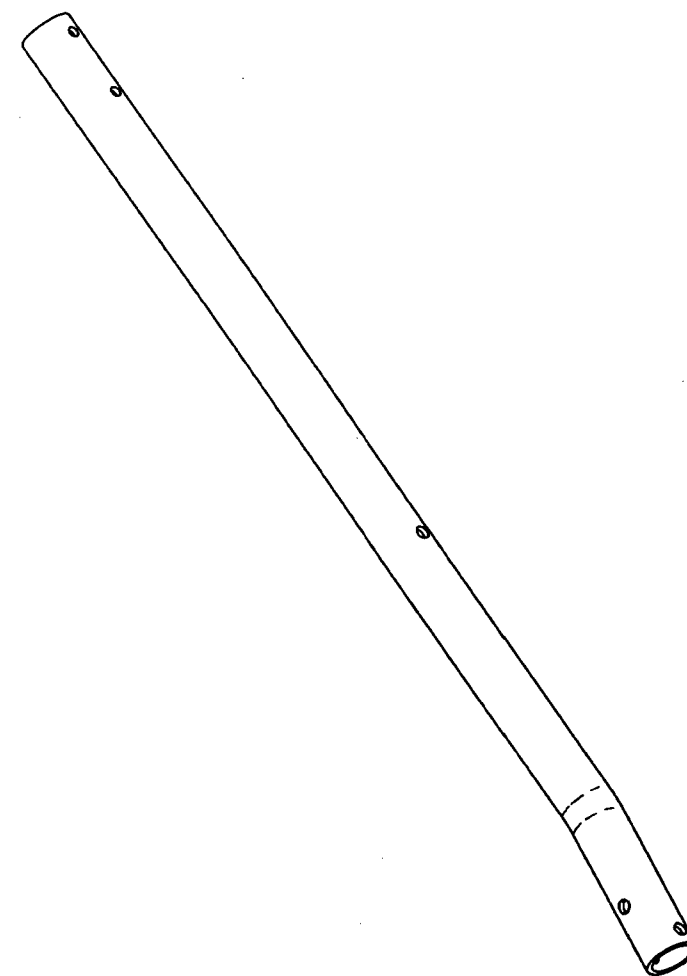
C

B

B

A

A



D3772-1 BACK LEG

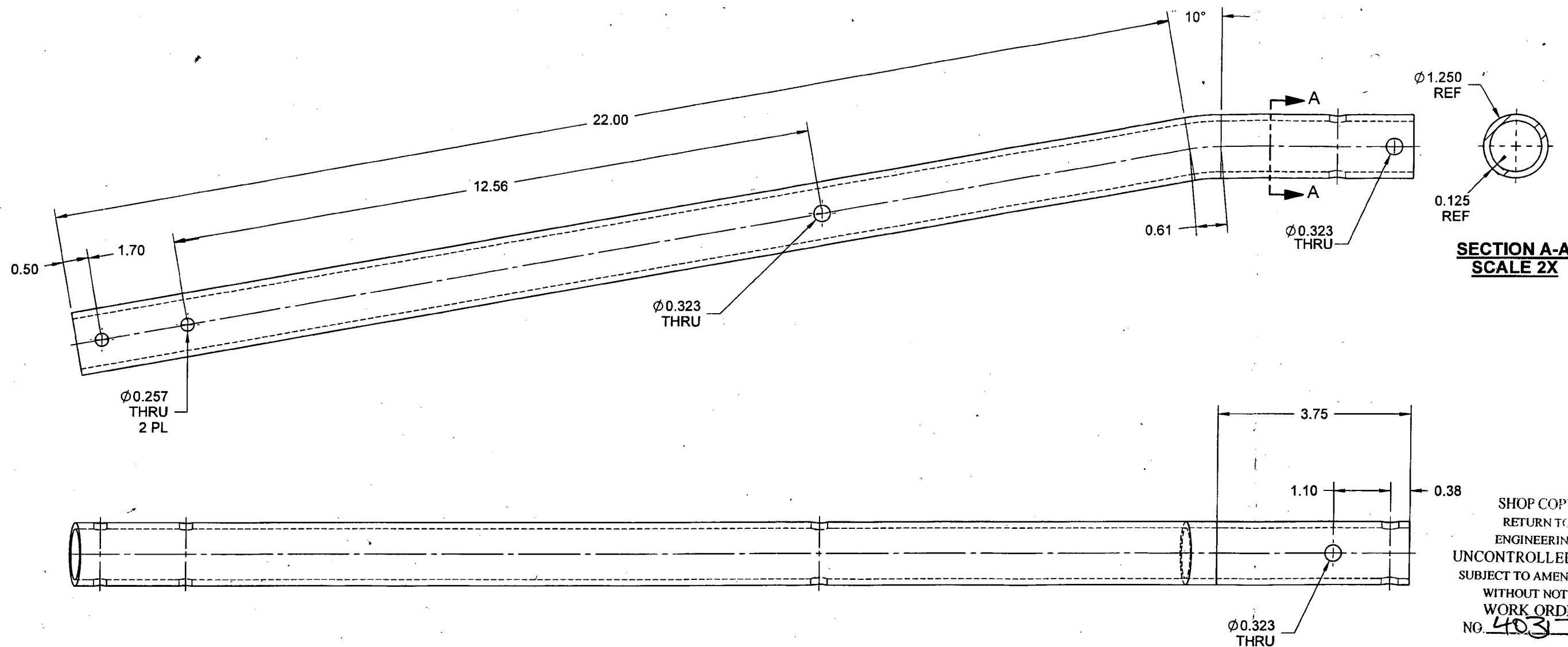
- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.26 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40317

RELEASED
08-06-13

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
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MFG. APPR.	<i>[Signature]</i>	D3772	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BACK LEG	NTS
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8 7 6 5 4 3 2 1



D3772-1 BACK LEG

RELEASED
08-06-14

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PS	DRAWING NO.	REV. A
MFG. APPR.	AA	D3772	SHEET 2 OF 2
APPROVED	JW	TITLE	SCALE
DE APPR.	TH	BACK LEG	NTS
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